

Work Order ID 53249

October 28, 2009 1:57:18 PM



Page 1

Item ID: PB67-43001-45

Revision ID: C

Item Name: Longitudinal Support

Start Date: 10/29/2009 Start Qty: 1.00

Required Date: 11/16/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: YMFDate: 09-10-28 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001	c

100



Small Fab

0.00

Small Fab

Memo

0.00

1- Align drill -97 and -357 using existing pilot hole of -357 as per dwg ✓

2- install spring pin ✓

110



QC5- Inspect part completeness to step on W/O

0.00

⇒ Small Fab

QC

Quality Control

0.00

120



Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

M~~08/18/44~~

Powdercoat

Powder Coating

Memo

START TIME: 2:30OVEN TEMPERATURE: 320°FINISH TIME: 3:00

0.00

08/09/12-17

(1x)

(09/12/10)

(2)

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53249

October 28, 2009 1:57:18 PM



Page 2

Item ID: PB67-43001-45

Revision ID: C

Item Name: Longitudinal Support

Start Date: 10/29/2009 Start Qty: 1.00

Required Date: 11/16/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

11/09-12-17

0.00

130



QC

Quality Control

Memo

140



Small Fab

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble parts as per dwg

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

2) S 10/01/04

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53249

Page 3

October 28, 2009 1:57:18 PM

Item ID: PB67-43001-45

Revision ID: C

Item Name: Longitudinal Support

Start Date: 10/29/2009 Start Qty: 1.00

Accept



Setup Start



Required Date: 11/16/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center ID

160



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: SLSet Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/29/09**10/29/09**PC 10-1-06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 28, 2009 1:57:17 PM

Page 1 /15

Work Order ID: 53249



Parent Item: PB67-43001-45RevC



Parent Item Name: Longitudinal Support

Start Date: 10/29/2009

Required Date: 11/16/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

PB67-43001-97RevC



Manufactured

No

100 Each 0.0000 1.0000

341869 → ① ✓ 10/12/16

Clevis

PB67-43001-357RevB1



Manufactured

No

100 Each 11.0000 1.0000



Tube Arm

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST

11

41508

11

240-107



Purchased

No

100 Each 74.0000 1.0000

① ✓

SPRING SLOTTED PIN

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST

74

D3447-1RevA



Manufactured

No

140 Each 11.0000 1.0000

① ✓

Round Spacer

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST

11

41179

3

41458

8

① ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 28, 2009 1:57:17 PM

Page 2 /5

Work Order ID: 53249



Parent Item: PB67-43001-45RevC



Parent Item Name: Longitudinal Support

Start Date: 10/29/2009

Required Date: 11/16/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3447-5RevA



Manufactured

No

140

Each

16.0000

1.0000

Clevis

pl09/12/16

Warehouse

Location

Main Warehouse

ST

Loc Qty

16

39967

41459

1

15

30345T21



Purchased

No

140

Each

41.0000

1.0000

LANYARD

① ✓

Warehouse

Location

Main Warehouse

ST

Loc Qty

41

17828

41

① ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 28, 2009 1:57:17 PM

Page 3/15

Work Order ID: 53249



Parent Item: PB67-43001-45RevC



Parent Item Name: Longitudinal Support

Start Date: 10/29/2009

Required Date: 11/16/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-13A 		Purchased		No		140	Each	289.0000	1.0000	M/13359 → ① 113359	10/29/16	

Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	289	
107321	1	
107534	5	
107959	23	
109285	37	
110552	66	
110865	3	
111477	9	
111925	7	
112314	138	
17406	0	
51764	0	

BSP43



Purchased

No

140

Each

114.0000 1.0000

RIVET

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	114	
109119	20	
110704	50	
111127	44	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 28, 2009 1:57:17 PM

Page 4 15

Work Order ID: 53249



Parent Item: PB67-43001-45RevC



Parent Item Name: Longitudinal Support

Start Date: 10/29/2009

Required Date: 11/16/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS17984-C410



Purchased

No

140

Each

20.0000

1.0000

10/29/16

QUICK PIN REPLACEMENT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

20

111119

15

18118

5

MS21042L4



Purchased

No

140

Each

5,920.000 1.0000



Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

5920

110507

184

111827

5727

112314

9

15924

0

1 ✓

10/29/16

1 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section.C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 28, 2009 1:57:17 PM

Page 5 / 15

Work Order ID: 53249



Parent Item: PB67-43001-45RevC



Parent Item Name: Longitudinal Support

Start Date: 10/29/2009

Required Date: 11/16/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149D0416J



Purchased

No

140

Each

175.0000

2.0000

Washer

Oct 29/16

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

175

10538

77

13910

98

② ✓

NAS1149DN416J



Purchased

No

140

Each

0.0000

1.0000

Washer

m13910 → ① Oct 29/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

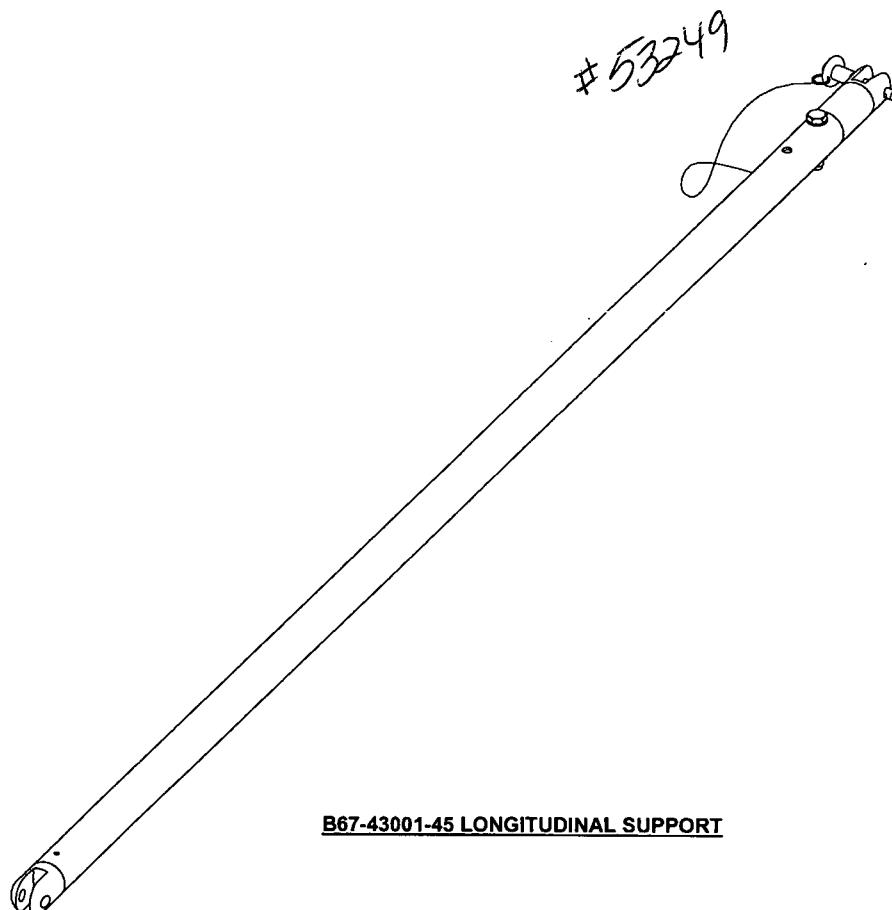
C

B

B

A

A



B67-43001-45 LONGITUDINAL SUPPORT

ITEM	QTY -45	P/N	DESCRIPTION
1	X	B67-43001-45	LONGITUDINAL SUPPORT
3	1	B67-43001-97	CLEVIS
4	1	B67-43001-357	TUBE ARM
5	1	D3447-1	ROUND SPACER
6	1	D3447-5	CLEVIS
8	1	30345T21	LANYARD
9	1	AN4-13A	BOLT
10	1	CR3213-4-2	RIVET (OR BSP43-2)
11	1	MS17984-C410	QUICK RELEASE PIN
12	1	MS21042L4	NUT
13	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
14	2	NAS1149D0416J	WASHER
15	1	NAS1149DN416J	WASHER

RELEASED
2009-08-24
MM

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.			MB	09.06.25
REV.	DESCRIPTION	BY	DATE		
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN		DRAWING NO.	REV. C		
CHECKED	AS	B67-43001-45	SHEET 1 OF 2		
MFG. APPR.	MM	TITLE	SCALE		
APPROVED	MM	LONGITUDINAL SUPPORT	NTS		
DE APPR.	N/A				
DATE	09.06.25				

COPYRIGHT © 1995 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8

7

6

5

4

3

2

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

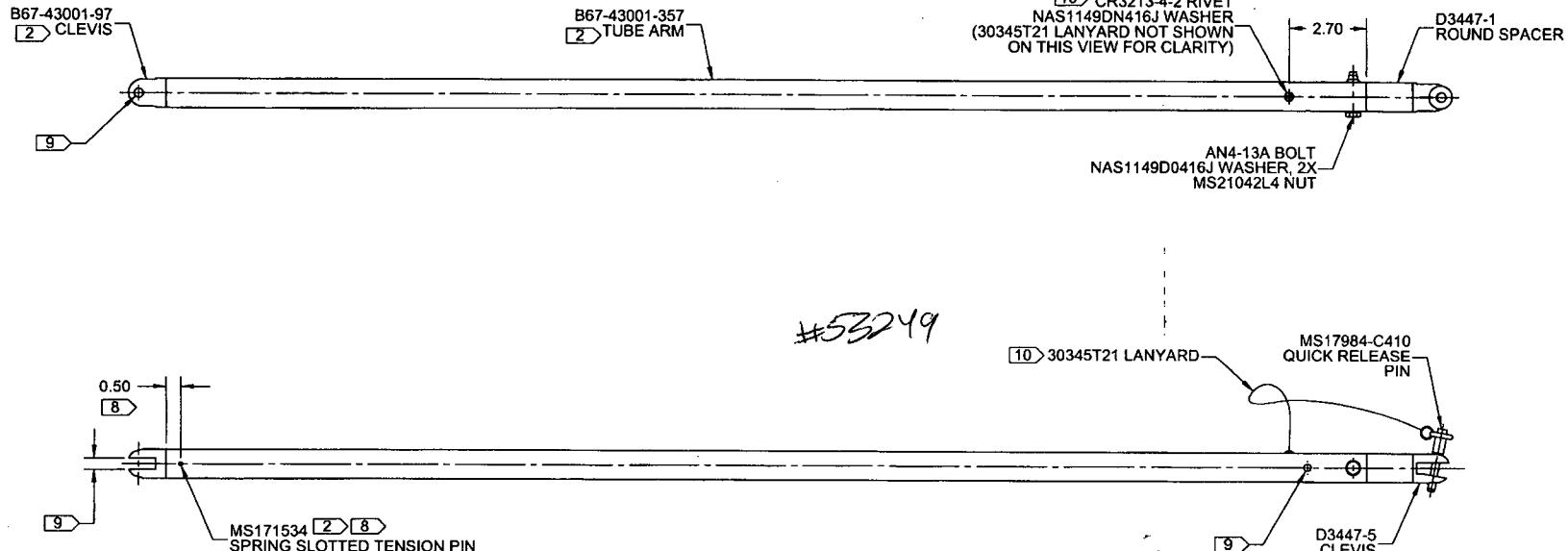
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

B67-43001-45 LONGITUDINAL SUPPORT

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs
- 8) PRIOR TO POWDER COAT, ALIGN B67-43001-97 ON B67-43001-357 AS SHOWN AND DRILL A Ø0.129 HOLE THROUGH BOTH PARTS. FASTEN B67-43001-97 TO B67-43001-357 USING MS171534 SPRING SLOTTED PIN.
- 9) MASK PRIOR TO POWDER COAT
- 10) BEFORE OR AFTER POWDER COAT, DRILL A Ø0.129 HOLE IN B67-43001-357 TO INSTALL THE LANYARD. DRILL THROUGH ONE WALL ONLY. AFTER POWDER COAT, INSTALL 30345T21 LANYARD ON B67-43001-357 AS SHOWN USING CR3213-4 TYPE RIVET AND NAS1149DN416J WASHER.

8 7 6 5 4 3 2 1

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	
MFG. APPR.	AM	REV. C	
APPROVED	AM	B67-43001-45	
DE APPR.	N/A	SHEET 2 OF 2	
TITLE		SCALE	NTS
LONGITUDINAL SUPPORT		DATE	09.06.25
COPRIGHT © 1995 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS			
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT			
WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries